Work Order ID 99628 Page 1 April-11-13 2:25:38 PM Item ID: D2344 Accept *N900040100* Setup Start **Revision ID:** Stop Litter Deck Plate, 350 Item Name: Start Qty: 6.00 **Start Date:** 4/11/13 **Cust Item ID:** Required Date: 4/11/13 Req'd Qty: 6.00 **Customer:** Reference: Run Start Date: 13-01-16 Tooling: Date: Approvals: Stop Date: QC: **SPC (Y/N):** Date: Tool ID Accept Reject Reject Sequence ID/ Set Up/ Tool # Plan Insp. **Operation** Work Center ID Description Qty Qty Code Number Stamp **Run Hours Draw Nbr Revision Nbr** D2344 Rev F 100 0.00 FLOW WATER JET Jm3-09-16 *100* 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per dwg 2024,063 2-deburr as required

Jm13-09-10

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110-

QC

Quality Control

											DQ	۹:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C	CON	IFOR!	MANCE / UPI	DATE			•	
											QA Close	d:	Date:	
NA/ a valv O vad						DISPOSITION				AGAINST D	EPARTMEN	IT/PROCESS		
Work Ord	er:					Rework	ıl		Skid-tube	Crosstube	٦	Water J	et 🗀	Engineering
Dort N	d o					Scrap	 		Machining	Small Fab	۱ ,	rod. Eng. Cod		Quality
Part N	VO.					Use-as-is	1		noforming	Finishing		tore/Packagi		Other
NCR I	Nο					Work Order Update	1		Large Fab	Composite	1 1100/3	Suppl		
New	10.					Work Order opaute	¹		zar8e raw		_1			!
Root		76			Descri	ption of work order update	Ī	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verifica	tion	QC Inspector
Doc/Data														
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Operator							1				j ·			
Material]		1							
Setup														
Other														
Process						,								
Supplier														
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Unapproved		<u> </u>					<u> </u>							
						F	AUL	T CATE	GORY					
Landi	_	1				General		ì		Γ	-			1
		Bending				Bend	-	Grain		ļ	Ovalized		<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	Hardwa		ļ		der tolerance	\vdash	Temperature/Cure
		Cracks				Broken/Damaged	-		ion Incomplete	<u> </u>	Part Inco		<u> </u>	Weld
,		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear [Part Lost,	/Missing	L_	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord		628		*996	328*			·				Page 2
Item ID: Revision ID: Item Name:	D2344 Litter Deck Pl	ate, 350		Accept	*N900	<u>040</u>	100)*	Setup S	Start Stop	*NS	S1* S2*
Start Date: Required Date: Reference:	4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	i D :						. 17
Approvals:		in:				ate:		1		Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - secondary Memo	ond check	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
*130 *130* Small Fab Small Fab		Small Fab Memo 1-Deburr sh	narp edges 2-Countersin	0.00 0.00 k holes per Dwg D2344				6×		-		Js/s
140 *140* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00 B 9	1			6	<u> </u>			

NCR: Ye	es / No					WORK ORDER NON-C	100	VFOR	MANCE /	UPDA	TE	QA Closed:	Date:	
			- • \$0		\neg	DICDOCITION			a constant		ACAINSTOS	7		
Work Order	r:				ı	DISPOSITION					AGAINST DE	PAKTIVIENT/	PROCESS	
						Rework			Skid-tube		Crosstube		Water Jet	Engineering
Part No	o				١	Scrap	J I		Machining		Small Fab	ł	d. Eng. Coor.	Quality
	•				I	Use-as-is			noforming		Finishing	Rec/Stor	e/Packaging	Other
NCR No	o					Work Order Update	֡		Large Fab		Composite		Supplier	
Root			·	Desc	crip	tion of work order update		Initial		Action		Sign &		
Cause	Date	Step	Qty		0	r Non-conformance	Ch	nief Eng	D	Descript	ion	Date	Verification	QC Inspector
oc/Data														
quip/Tooling		1.										:		
perator														
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etup		1					,							
Other	_			٠				•						ŧ
rocess	_	ļ												
upplier	_													,
raining												:		
Inapproved		<u> </u>	<u> </u>				<u> </u>		0051/					
		1.00					AUL	T CATE	GORY					
Landing				г	_	General	_	10				10 -1:1		Pressure/Forced
-	Bending			_		Bend	-	Grain			<u> </u>	Ovalized		-
-	Centre N	ot Concei	ntric to	0/5		BOM/Route	-	Hardwa			-	Over/Under	-	Temperature/Cure Weld
-	Cracks	·		}		Broken/Damaged	-	4	on Incomplet			Part Incorred	 	Wrong Stock Pulled
	Crushed/	Crimpea.		}	_	Burrs	\vdash	4 - *	ions Incompl	iete/Unc	lear	Part Lost/Mi Part Moved	221118	
-	Cuffs			`}		Contamination	-	Mainte		•		4	Vrance	
-	Heat Trea		T. 1-	}	—	Countersink	-	Mislabe			}	Positioned V		Other
-	Inspectio		rupe	}	\rightarrow	Cut Too Short	-	Misread	ı		L_	Power Loss/	Juige	Other
-	Ripples in		·		┙	Drill Holes	\vdash	Offset	7					
-	Torque V			n		Drawing	\vdash	4	Calibration					
-	Turning S			}	$\overline{}$	Finish	\vdash	1	Sequence				<u></u>	
	Wave/Tw	vist in Tul	oe e	1		Folio	1	J Outside	Dimensions	;				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order April-11-13 2:25:.		28		*996	28*				Page 3
Revision ID:	2344 itter Deck Plat	e. 350	-	Accept	*N90004	\1\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	k Se	tup Start Stop	*NS1*
	11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:				INCOZ
		:	Date:	Tooling: SPC (Y/N):	Date:		Ru	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 150 *150* HandFinish Hand Finishing]	Operation Description Chemical Conversion Coa	nt per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool		Accept Qty	Qty	Reject Insp. Number Stamp
*155 *155* QC Quality Control		QC7-Inspect Chemical Co	onversion Coat	0.00		6_	X 9/1	mf	13/69/17
*160 *160* Powdercoat Powder Coating	7	Memo START TIME	7/1	0.00 45 0.00 OVEN TEMPERATURE	· · · · · · · · · · · · · · · · · · ·	6,	XY	MJ	13/04/17

M117338

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed:	Date: OCESS Vater Jet Engineering
Work Order: DISPOSITION AGAINST DEPARTMENT/PRO	Water let Engineering
Rework Skid-tube Crosstube W Part No. Scrap Machining Small Fab Prod. En Use-as-is Thermoforming Finishing Rec/Store/Pa	ng. Coor. Quality
Root Description of work order update Initial Action Sign &	
	erification QC Inspector
Doc/Data	
FAULT CATEGORY	
Landing Gear General	
Bending Bend Grain Ovalized Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolers Cracks Broken/Damaged Inspection Incomplete Part Incorrect Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong	Weld Wrong Stock Pulled
Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge	ge Other

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde April-11-13 2:2		628		*996	328*					Page 4
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D2344 Litter Deck Pl 4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6 *6		*N900 Cust Item I Customer:		100)* Setup	Star Stop	ועיאו
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		Run	Star Stop	"NR1"
Sequence ID/ Work Center II 170 *170* QC Quality Control 180 *180* Packaging	D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Stock Memo	ck Location: 5	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept R Qty Q	4	Reject Insp. Number Stamp II 13-69-17
Packaging 190 *1 Q QC Quality Control		QC21- Final Inspection - \ Memo	Work Order Relea	se 0.00 0.00				H)	N 12	<u>-09-11</u>

										DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-CONFORMANCE / UPDATE						Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.	·				Work Order Update]	1110111	Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other	_		1									
Process												ĺ

Landing C	Gear	General			_	 •
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Г	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration	·	
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Supplier Training Unapproved

Picklist Print

April-11-13 2:25:38 PM

Work Order ID:

99628

Parent Item:

D2344

Parent Item Name:

Litter Deck Plate, 350

Start Date: 4/11/13

Required Date: 4/11/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M2024T3S.063		Purchased	No			100	sf	127.5800	0.745	4.705263	-	-T. 3 .0
2024-T3 .063 sheet									f	<u> </u>	/	Jm309
				Location		Loc Oty	Lo	c Code				
				MAT022		127.58						
				1199	16	0.2						
				1211	97	21.34						
				1230	96	11.4						
				1236	54	11.64						
				1237	01	83						
									. 1~	-1 51		

125636

125636

											DQA	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UP	DATE			
						·			1000 00000	and the second second second	QA Closed	: Date:	Carlos Ca
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	_					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet od. Eng. Coor.	Engineering Quality
NCR I	_					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	4	ore/Packaging Supplier	Other
Root					Descri	ption of work order update	[]	Initial	Ac	tion	Sign &		
Cause	ļ	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data			1										
Equip/Tooling			1										
Operator			1										
Material				}									
Setup										N. P.			
Other													
Process													
Supplier													
Training			:										
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ing G	ear				General		•			-		-
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	\Box	Centre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa	ire		Over/Unde	r tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	79428
Description: Litter Deck Plate Kit (350)	Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		_				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.227"	-		V	JAMOI
5.598	+/-0.010	5,599"	_		V	
4.869	+/-0.010	4.873"	-		V	
3.889	+/-0.010	3.893"	-		V	
3.096	+/-0.010	3.099"	-		V	
2.891	+/-0.010	2.897	_		V	
16.973	+/-0.010	16.973	- ;		丁	JKMOG
0.450	+/-0.010	0.457	_		V	
4.423	+/-0.010	4.427	_		V	
4.723	+/-0.010	4.729"	-		V	
1.202	+/-0.010	1.208,			v ·	
5.869	+/-0.010	5.969"	-		V	,
4.654	+/-0.010	4.658"	-		v	
Ø0.656	+0.005/-0.000	0.656"	_		V	
1.888	+/-0.010	1.890	-		V	
2.285	+/-0.010	7.787"	_		1	
2.683	+/-0.010	5.682,	_		V	
Ø0.171	+0.005/-0.000	Q.172"	_		V	
3.491	+/-0.010	3.499"			٧	
Ø0.191	+0.005/-0.000	0/94"	_		V	
3.123	+/-0.010	3125"	-		V	
1.975	+/-0.010	1.980°	_		V	
Ø0.128	+0.005/-0.001	0.129"	- 40		V	

Measured by: J_M
Date: 13 09-18

Audited by: 27
Date: 13 9 M

Date: N/A

Date: N/A

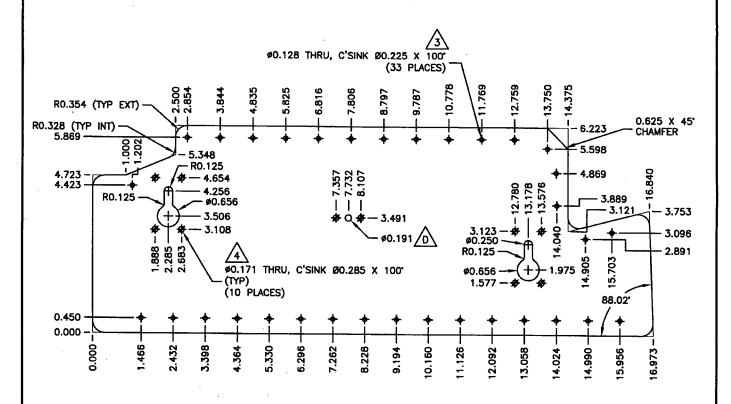
Rev	Date	Change	Revised by	Approved
Α	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
В	07.07.17	Dwg Rev. updated	KJ/JLM	
O	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM 🔏	E
			- · · · · · · · · · · · · · · · · · · ·	



DESIG KE	1	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED IZ	APPROVED //	DRAWING NO.	REV. F
	-#	101	D2344 SHEET	1 OF 1
DATE	DATE		TITLE	SCALE
07.06.07			LITTER DECK PLATE, 350	1:3
Α		95.01.14	NEW ISSUE	
В		95.02.09	MOVED KEY HOLES	
D		95.03.06	0.191 WAS 0.197	
E		98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

C'SINK Ø0.285 WAS Ø0.308

99428 NBOH 11



07.06.07

F

D2344 LITTER DECK PLATE, 350

E 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 (REF. DART SPEC. M2024T3S)

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3

3) COUNTERSINK HOLES MARKED ★ TO \$0.225 X 100°

4) COUNTERSINK HOLES MARKED ★ TO \$0.285 X 100°

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

RELEASED

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